

Date: Wednesday, 20/09/2006 7:21:37 AM  
User: Linda Lacelle

## **Process Sheet**

| Customer  | : CU-DAR001 Dart Helicopters Services                         | Drawing Name                 | : 205 SKIDTUBE "I" BEAM          |
|---|---|------------------------------|----------------------------------|
| Job Number  | : 28651   |                              |                                  |
| Estimate Number   | : 10346   |                              |                                  |
| P.O. Number   | : N/A   | Part Number                  | : D2596                          |
| This Issue  | : 20/09/2006 S.O. No. : N/A                                   | Drawing Number               | : D2596 REV C                    |
| Prsht Rev.  | : NC  | Project Number               | : N/A                            |
| First Issue   | : N/A   | Drawing Revision             | : C                              |
| Previous Run  | : 28493   | Material                     | : N/A                            |
| Written By  | : <u>JL</u>   | Due Date                     | : 27/09/2006                     |
| Checked & Approved By   | : <u>JL</u>   | Qty:                         | 2 Um: Each                       |
| Comment   | : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M |                              |                                  |
| <b>Additional Product</b>   |   |                              |                                  |
| Job Number:    |   |                              |                                  |
| Seq. #:   | Machine Or Operation:   | Description :                |                                  |
| 1.0   | D25003100   | Ex'tn -'I' Beam Web 4"       |                                  |
|    |   |                              |                                  |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)<br>Extrusion "I" Beam Web 4"<br>Pick;   |   |                              |                                  |
| Qty   | Part Number   | Description                  | Batch                            |
| 1   | D2500-3-100   | Extrusion                    | <u>B25751</u> <u>BT 06-09-20</u> |
| 2.0   | LANDING GEAR 1  | LANDING GEAR RESOURCE 1      |                                  |
|    |   |                              |                                  |
| Comment: LANDING GEAR RESOURCE 1<br>1- Cut D2500-3-100 to length: 99.5" }<br>2- Use Jig DT8093 to drill pilot holes #30 }<br>3- Open to 0.625" diameter using a uni-bit }<br>4- Deburr <u>BT 06 09 - 20</u> |   |                              |                                  |
| 3.0   | HAND FINISHING1   | HAND FINISHING RESOURCE #1   |                                  |
|    |   |                              |                                  |
| Comment: HAND FINISHING RESOURCE #1<br>Acid Etch and Alodine per QSI 005 4.1 <u>BT 06 09 - 20</u>   |   |                              |                                  |
| 4.0   | QC5   | INSPECT WORK TO CURRENT STEP |                                  |
|  <u>Prm 06-9-20</u> <u>(2)</u>      |   |                              |                                  |
| Comment: INSPECT WORK TO CURRENT STEP   |   |                              |                                  |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/09/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                  |                                 |                |                           |                       |                          |
|------|------|----------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action      Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng             | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                  |                                 |                |                           |                       |                          |
|      |      |                                  |                                  |                                 |                |                           |                       |                          |
|      |      |                                  |                                  |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 20/09/2006 7:21:37 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 28651

Part Number: D2596

Job Number:



| Seq. #: | Machine Or Operation: | Description :         |
|---------|-----------------------|-----------------------|
| 5.0     | PACKAGING 1           | PACKAGING RESOURCE #1 |

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

Pm 06-9-20(2)



|     |      |                              |
|-----|------|------------------------------|
| 6.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|-----|------|------------------------------|



(2)

Comment: FINAL INSPECTION/W/O RELEASE

06/09/21

Job Completion



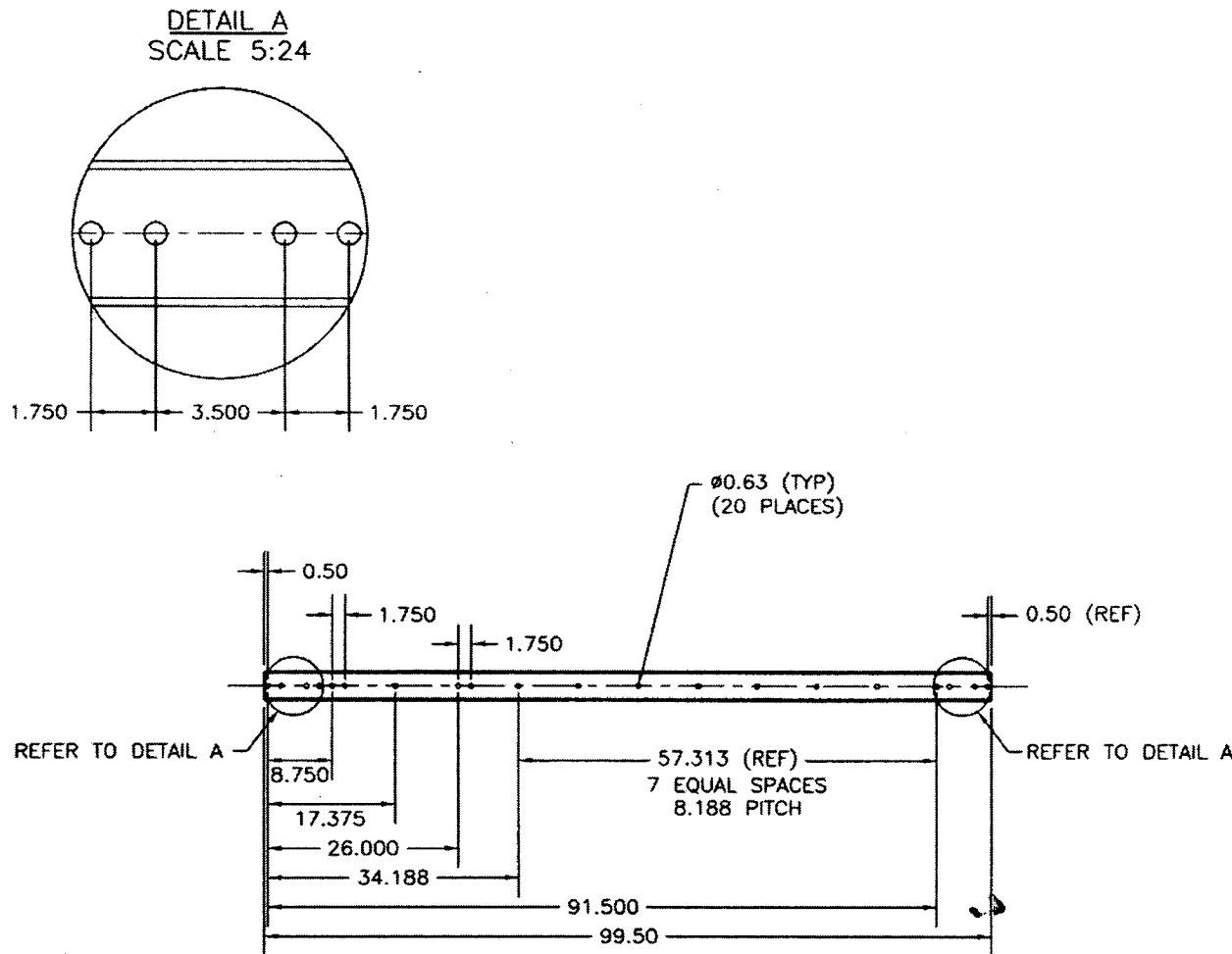
06-9-20(2)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



MANUFACTURED FROM D2500-3 EXTRUSION  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY

RELEASED  
18.09.17 DS

**DART**



|                               |                                |   |
|-------------------------------|--------------------------------|---|
| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2596                              |
| DATE<br>98.09.14              | TRUE<br>205 WEB                | SHEET 1 OF 1                                      |
| A                             | 96.09.16                       | NEW ISSUE   |
| B                             | 97.07.23                       | Ø0.63 HOLE WAS Ø0.56                              |
| C                             | 98.09.14                       | INCORPORATED DEO 9097                             |

REV. C  
1:24  
SCALE

Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries